

**Commonwealth of Kentucky
Division for Air Quality**

EXECUTIVE SUMMARY

FINAL

Conditional Major Construction / Operating

Permit: F-08-025

Heaven Hill Distilleries, Inc.

October 20, 2008

Esmail Hassanpour, Reviewer

SOURCE ID: 21-179-00005

AGENCY INTEREST: 3255

ACTIVITY: APE20080002

SOURCE DESCRIPTION:

Heaven Hill Distilleries, Inc. applied to the Kentucky Division for Air Quality on June 11, 2008, to renew their permit in Bardstown, KY. The source currently holds operating permit (F-03-024R1) for their whiskey processing and bottling plant. The source is planning to construct a 7225 square foot tank room to house eight additional 14,000 gallon, stainless steel processing/bottling tanks. The facility proposes to replace the current barrel dumping system with a four station vacuum evacuation system with integrated water rinse. The existing dump room tanks will be relocated and one additional dump room tank will be added. Emission point #12 Mixing/Processing Tanks in the draft permit, has been renumbered as Emission Point #13. Barrel Filling Equipment constructed in 2005, is now Emission Point #12. The unit which was erroneously left out in the renewal application has now been added to the permit, and to match the source's emission point descriptions.

At this facility, tankers of distillate are unloaded into cistern room storage tanks where the proof (alcohol content) of the liquid is adjusted using de-ionized water. The liquid is then placed in barrels and transported to warehouses for aging. The vacuum system which consists of automated barrel handling conveyors and four station vacuum evacuation unit will remove the aged whiskey from the barrel, via a wand, rinse the interior of the barrel with water; then remove the rinse water. The whiskey and rinse water are pumped to dump room tanks where the weight and proof of the product is gauged. The gauged volume of whiskey is then pumped to storage or processing tanks. Inside the processing area, the whiskey proof may be adjusted again before the product is filtered and pumped to bottling. Finally, the product is labeled and packaged for storage and shipping.

PUBLIC AND U.S. EPA REVIEW:

On September 19, 2008 the public notice on availability of the draft permit and supporting material for comments by persons affected by the plant was published in Bardstown, KY Standard Nelson, Kentucky. In addition, notification of the issuance of the draft permit was sent to the U.S. EPA on September 11, 2008 via e-mail. The public comment period expired 30 days from the date of publication. No comments were received during this period. The permit is now being issued final.